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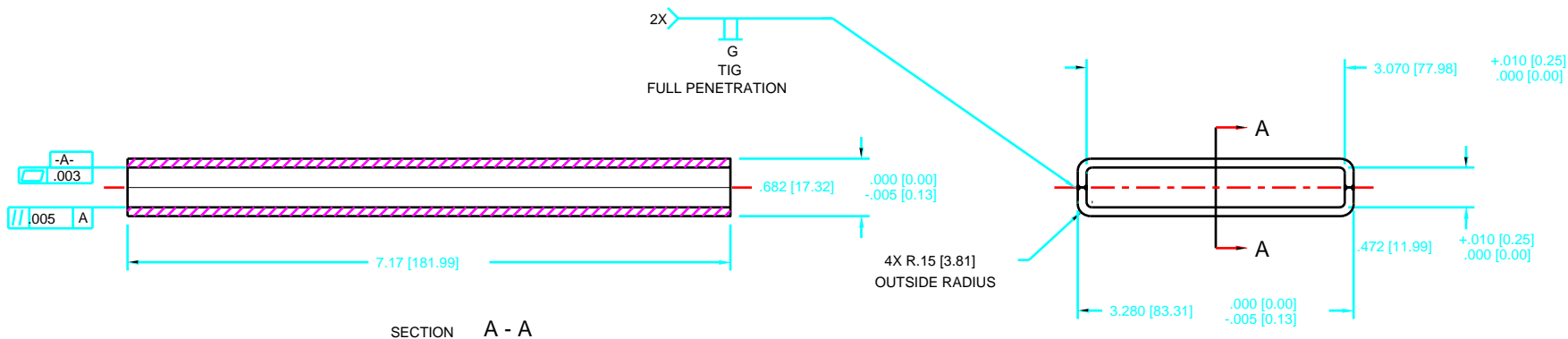
PLOT SCALE:

1=1

DWG. SCALE:

1

A14328



NOTES:

1. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
A) CIMCOOL 5 STAR 49
B) TRIM SOL
2. THIS IS A UHV PART, ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTROPOLISHING, THE PART NEEDS TO GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN.
3. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
4. DIMENSIONS IN [] ARE MILLIMETERS AND FOR REF. ONLY

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES				
TOLERANCES				
DECIMALS				
ANGULAR				
X - .03 [.7620] - .25				
XX - .01 [.254] - .125				
XXX - .005 [.127] - .125				
SURFACE ROUGHNESS 125				
REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX.				
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1				
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5				
DO NOT SCALE DRAWING				
LOG NUMBER A1432800		THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY		
DRAWN BY MUSCIA	DATE 10/22/93	CHIEF DESIGN ENGINEER D. SHU	DATE 11/15/93	TITLE ADVANCED PHOTON SOURCE V1 APS FRONT END 12 mm X 78 mm X 182 mm DIFFERENTIAL TUBE
CHECKED BY J. WOTHE	DATE 11/15/93	GP LEADER M. KUZAY	DATE 11/15/93	
DESIGNER SHU/MUSCIA	DATE 10/22/93	PROJECT MGR.		
RESPONSIBLE ENGINEER D. SHU	DATE 11/15/93	APPROVED/RELEASED		
MATERIAL 12 GA. (.105) 304 STAINLESS STEEL		SCALE 1:1 SHEET 1 of 1		
DRAWING NUMBER P4105090701-810101-00				